

41 5236428



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6101-007
Job Sheet 203976



Part No: D6101-007

Job Qty: 10 pcs

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/19

Job Tracking No:

Due Date: 12/13/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	10 pcs	12/13/19	12/13/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		DEC 02 2019
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	10 pcs	12/13/19	12/13/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B	DAS 81 9-89	
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		DEC 02 2019
							Packaging 2 - 13 - B4B	DAS 81 9-89	
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Container No: S236299



Part: D6101-007P

Job No: 203976

Serial No/Batch: S236299

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/02/19

Plex 11/29/19 2:47 PM Dart.Guerin.Kimberley

						B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
120 QC 18	10 pcs	12/13/19	0.00	0.00		QC 18 - 12	
						QC 18 - 14	
						QC 18 - 22	
						QC 18 - 25	
						QC 18 - 48	
						QC 18 - 58	
						QC 18 - 61	
						QC 18 - 9	
						QC 18 - 81	
130 Packaging 3-1 - Stock - B4B	10 pcs	12/13/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	

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				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	12/13/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	20
				QC 21 - SA - 53	DEC 03 2019

Part Op 100 - Issue P/O: _____ b) 7.750" x 8.250" x 2.50" thick d) Grain direction along 7.750" length
 Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs), Ensure material certification is attached
 120 - Ensure Material certification comply to Dwg D6101
 130 - (Identify as per dwg & Stock Location: _____), LOCATION: MAT041
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007P	7075-T7351 8.25X7.75X2.5	10 pcs (1 ea)	100-Purchasing	

Job Allocations

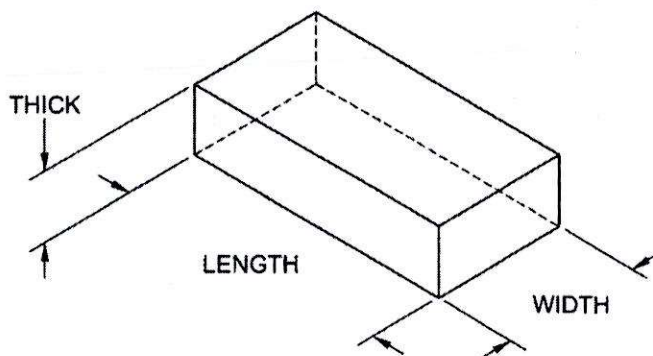
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6101-007P	10	0	0

Part Specifications

Specifications could not be found.

CIVE 1
D6101-007

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209 *003*

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/WP

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045044



Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W 0E9 Canada

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045044

PO Date: 11/8/19

Due Date: 12/3/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	203024	D6101-007P	D6102	72743	7075-T7351 8.25X7.75X2.5 : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075-T7351 (QQ-A-250/12) SIZE: 7.750" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 7.750" LENGTH TOLERANCE AS PER QUOTE +.030"/-.000"	Partial	-	12/3/19	30 pcs	20 pcs	10 pcs	\$61.72/pcs	\$617.20
										10 pcs Vn			
												NOV 29 2019	
2	203056	D6104-005P	D6202		17-4 SS Roundbar 4.00"Od : Various STC's AS PER DWG D6104 REV. B MATERIAL: 17-4 PH AS PER AMS 4643 OR AISI 630 SIZE: 4.00" X 5.10" LONG	Received	-	12/3/19	10 pcs	10 pcs	0 pcs	\$54.20/pcs	\$0.00
Grand Total:													\$617.20



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045044



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries. (DFARS)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, appearing to read "J. Guerin".

Plex 11/29/19 2:44 PM Dart.Guerin.Kimberley

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:4050173

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	Inco Terms	Freight Terms		Carrier		BOL No	
27-NOV-19	FCA HAWKESBURY ON CAN	Prepay & Add		LOCAL_FLEET		4050173-6	

Shipment Details			Final Destination Branch - TOR				
Order No	Line No	Item No	Description				
5652515	1	752241.MO	2.5000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT RECTANGLE TO 8.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.75")) X 7.75 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.75")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12				
Purchase Order No		Part Number	Ordered Qty	Invoice Qty			
POHB045044		YOUR ITEM NUMBER: D6101-007	10.00 PCS	10.00 PCS			
Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS						
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
122987779	CONSTELLIUM ROLLED PRODUCTS	 9 4 5 3 9 0 1		10			165.3169

These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. Government or as otherwise authorized by U.S. law and regulations.



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:



NOV 27 2019



CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

**S
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T
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A M CASTLE & COMPANY
4175 ROYAL DRIVE
KENNESAW GA
30144
US

**S
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O**

A M CASTLE
1420 KENSINGTON ROAD, SUITE 220
OAK BROOK IL
60523
US

A M CASTLE		110772126		4776		INCLUSION		Serial:20190619-0110772126		Pg 1of2	
CUSTOMER PURCHASE ORDER NO. & ITEM 504861						Constellium ORDER NO. 275168					
ALLOY 7075	CLAD	TEMPER T7351	GAUGE 2.50000 in 63.50 mm	WIDTH 48.50000 in 1,232 mm	LENGTH 144.50000 in 3,670 mm		CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Dave Dunbarger - Laboratory Manager				
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH											
CUSTOMER SPECIFICATION AMS 4078K											
PART NUMBER 752241		B/L NUMBER 119866		DATE SHIPPED 06/19/2019							
WT. SHIPPED 5355.000 LB		NO. OF PIECES 000003		GOVT. CONTRACT NO.							

ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS:

ASTM B594 REV 13 2013 100% SONIC W/ 0.12" DEADZONE Class A
AMS QQ-A-250/12A
AMS-STD-2154C 2017 TYPE1 CLASS A 100% SONIC MINUS DEADZONE
ASTM B209-14
BSS-7055B 2013 CLASS A 100% SONIC TESTED MINUS DEADZONE
CMMP025 REV V
CST1006 REV E 2011 CLASS A 100% SONIC MINUS DEADZONE
DPS 4.713 REV AK 2012 CLASS A 100% SONIC MINUS DEADZONE
GAMPS 9101 REV B 2006 CLASS A 100% SONIC MINUS DEADZONE
MMS 159T
PS 21211P 2010 CLASS A 100% SONIC MINUS DEADZONE

Load Details

Package	Net Lbs	Kg	Lot	Piece	Serial	Parent Lot
1002083512	1,785.000	809.662	9453901	01		
1002083512	1,785.000	809.662	9453901	02		
1002083513	1,785.000	809.662	9453901	03		

Lot: 9453901 (See test results below)

Tensile - Room Temperature (US)

		Ultimate (KSI)		Yield (KSI)		Elongation (%)		Report
Direction	Tests	Min	Max	Min	Max	Min	Max	
LT	02	72.1	73.0	61.0	62.5	12.0	12.0	





CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

S
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T
O

A M CASTLE & COMPANY

4175 ROYAL DRIVE
KENNESAW GA
30144
US

S
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T
O

A M CASTLE

1420 KENSINGTON ROAD, SUITE 220
OAK BROOK IL
60523
US

A M CASTLE 110772126 4776 INCLUSION Serial:20190619-0110772126 Pg 2of2

CUSTOMER PURCHASE ORDER NO. & ITEM 504861				Constellium ORDER NO. 275168		CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Dave Dunbarger - Laboratory Manager	
ALLOY 7075	CLAD	TEMPER T7351	GAUGE 2.50000 in 63.50 mm	WIDTH 48.50000 in 1,232 mm	LENGTH 144.50000 in 3,670 mm		
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH							
CUSTOMER SPECIFICATION AMS 4078K							
PART NUMBER 752241		B/L NUMBER 119866		DATE SHIPPED 06/19/2019			
WT. SHIPPED 5355.000 LB		NO. OF PIECES 000003		GOVT. CONTRACT NO.			

Tensile - Room Temperature (SI)							
		Ultimate (N/MM2)		Yield (N/MM2)		Elongation (%)	
Direction	Tests	Min	Max	Min	Max	Min	Max
LT	02	497	503	421	431	12.0	12.0

Conductivity % IACS MIN 39.6 MAX 40.2 % MS/M MIN 23.0 MAX 23.3

Chemistry (Actual)									
	SI	FE	CU	MN	MG	CR	ZN	TI	ZR
Core	0.07	0.18	1.44	0.02	2.51	0.21	5.39	0.03	0.00

OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER

All material contained in this lot was cast and manufactured in the USA

QUALITY TEXTS:
AMC CA-15413B R 10

THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.

CHEMISTRY BY OES: ARKSPARK
CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT
WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399. WHEN SMOOTH FATIGUE TESTED, TESTED PER ASTM E466.
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557
DUNS Number: 090570149; CAGE Code: 1YW19
100% Type I (Immersion sonic) used when ultrasonic inspection performed.
Mercury is not a normal contaminant in aluminum alloys and neither mercury nor any of its compounds were utilized in the

LINE 1
D6101-007

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-007

DATE: 2019-11-29

PO / BATCH NO.: POH13045044/

⇒ 5236299

MATERIAL CERT REC'D: YES

QUANTITY RECEIVED: 10 PCS

QUANTITY INSPECTED: 10 PCS

QUANTITY REJECTED: 0

THICKNESS ORDERED: 2.5 x 7.75 x 8.25

THICKNESS RECEIVED: 2.5 x 7.75 x 8.25

SHEET SIZE ORDERED: —

SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	ASTM B209
CORRECT THICKNESS	Y N	
PHOTO REQUIRED	Y N	
CORRECT REF # TO LINK CERT	Y N	
CORRECT MATERIAL IDENTIFICATION	Y N	
CORRECT M# ON THE MATERIAL	Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK.
RECORD RESULTS BELOW

	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION

ENGINEERING SIGNOFF (if required)

INSPECTED BY: _____

SIGNED OFF BY: _____

DATE: _____

DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in